

Work Order ID 114585

March-11-14 9:19:55 AM

114585

Page 1

Item ID: D3537-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearpad
 Start Date: 3/11/14 Start Qty: 80.00 *80* Cust Item ID:
 Required Date: 3/13/14 Req'd Qty: 80.00 *80* Customer:
 Reference:

Approvals: Process Plan: ✓ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3537	Rev C

100	FLOW WATER JET	0.00				89	EL	14-3-13	
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3537Dwg Rev: <u>✓</u> Prog Rev: <u>✓</u> 2-Deburr if necessary								

110	QC2- Inspect parts off machine FAI/FAIB	0.00				89	EL	14-3-13	
110									
QC	Memo	0.00							
Quality Control									

120	QC8- Inspect parts - second check	0.00				(89)	14-03-14		
120									
QC	Memo	0.00							
Quality Control									

DAS
9
9-89

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DAS
9
9-88

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Item ID: D3537-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearpad

Start Date: 3/11/14 Start Qty: 80.00

80

Cust Item ID:

Required Date: 3/13/14 Req'd Qty: 80.00

80

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

85 14-03-20 **DAS**
9-89

170

Grey Sandtex(Ref:4.3.5.6) per OSI005 4.3

0.00

170

Powdercoat

Memo

0.00

Powder Coating

START TIME: 9:00 OVEN TEMPERATURE: 935
FINISH TIME: 9:35

89 4-3-21 **DAS**
9-89

180

QC3- Inspect Part Finish

0.00

180

QC

Memo

0.00

Quality Control

DAS
27
9-89
4/3/21

89 _____

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Item ID: D3537-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearpad

Start Date: 3/11/14

Start Qty: 80.00

80

Cust Item ID:

Required Date: 3/13/14

Req'd Qty: 80.00

80

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location: FP-001

0.00

190

Packaging

Memo

0.00

Packaging

289 6 24 11/03/14

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

MLJ 14-03-21

AP 14-03-21

Picklist Print

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Work Order ID: 114585

114585

Parent Item: D3537-1

D3537-1

Parent Item Name: Wearpad

Start Date: 3/11/14

Required Date: 3/13/14

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA

Purchased

No

100

sf

319.9370

0.106

9

M304S16GA

304/316 Sheet .063

**

12 / 4-3-13

Location

Loc Qty

Loc Code

MAT020

319.937

M126915

1.487

M127821

126.13

M128054

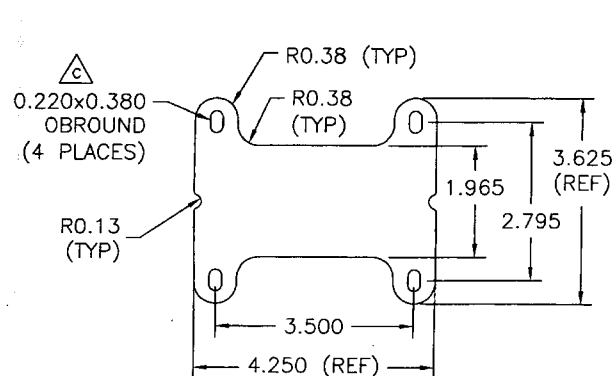
64.32

M128423

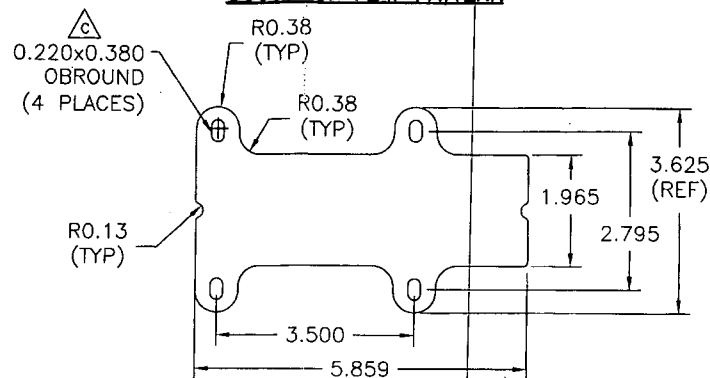
128

11.3

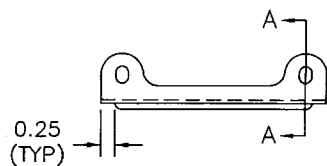
D3537-1F FLAT PATTERN



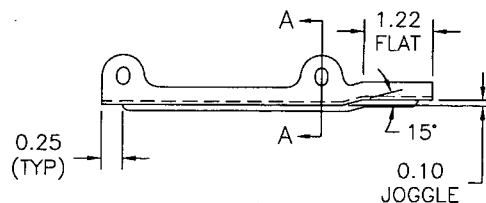
D3537-3F FLAT PATTERN



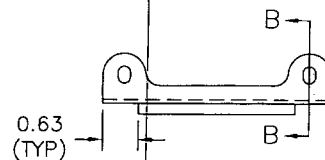
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



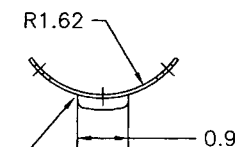
D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-1/-3/-5/-7 WEARPAD NOTES

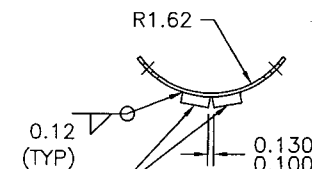
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SECTION A-A



APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

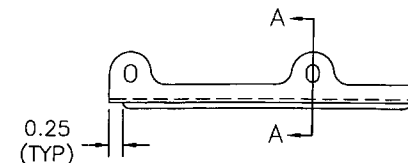
SECTION B-B



D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

RELEASED
07.05.08 AH
PER EGN
962

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	4	APPROVED 4
DATE	07.04.13	TITLE WEARPAD
DRAWING NO. D3537		REV. C
SHEET 1 OF 1		SCALE 1:2

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